

Work Order ID 51983

September 11, 2009 8:59:07 AM



Page 1

Item ID:	D3884-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Saddle, Inboard LH					
Start Date:	09/11/2009	Start Qty:	4.00	Cust Item ID:		
Required Date:	09/23/2009	Req'd Qty:	4.00	Customer:		

Reference:

Approvals:	Process Plan:	<i>mf</i>	Date:	09-09-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3884	B								

100



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

Program Batch No. *SP*

Double check by: *SP*

1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets

0.00

SP 09/09/21

2

1

P10

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

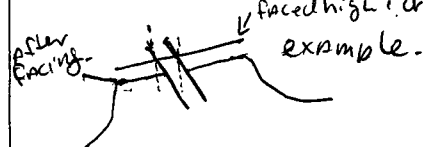
SP 09/09/21

2

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3884-1 → D119-646 PAR #: _____ Fault Category: Prod. Machineed Parts NCR: (Yes) No DQA: / Date: 05-10-05
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 05-10-05

NCR: 51983		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/09/21	100	One Saddle hole came over side on the through bolt location. In an attempt to avoid making the part scrap , the R.E. operator ERROR engraved surface too thin etc. operator faced it high then drilled the holes for the x-tube. When the thickness was faced again, the holes were off center because they are drilled in an angle. R.E. operator error.	<u>OS</u> 05.09.21 pc OS/WHZ	Replace Billet 6101-033 Batch. 46413 qty 1 Scrap PART	<u>SS</u> 09/09/21 OS/WHZ	<u>OS</u> 05.09.21 pc OS/WHZ	<u>OS</u> 05.09.21	<u>OS</u> 05.09.21
		the holes for the x-tube. When the thickness was faced again, the holes were off center because they are drilled in an angle. R.E. operator error.	<u>OS</u> OS/WHZ				<u>OS</u> OS/WHZ	<u>OS</u> 05.10.05
		after facing - 						

NOTE: Date & initial all entries

Work Order ID 51983

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Item ID:	D3884-1	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Saddle, Inboard LH					
Start Date:	09/11/2009	Start Qty:	4.00		Cust Item ID:	
Required Date:	09/23/2009	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>2</u>			
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<u>2</u>			
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:00am OVEN TEMPERATURE: 320°F FINISH TIME: 9:30am	0.00 0.00				<u>2x</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51983

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Item ID: D3884-1

Accept



Setup Start



Revision ID: B

Item Name: Saddle, Inboard LH

Stop



Start Date: 09/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/23/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

PR 0909-23

(2)



QC

Memo

0.00

Quality Control

160

Identify as per dwg & Stock Location: *U29*

0.00



Packaging

Memo

0.00

Packaging

9/19/23 (2x) SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/24

MF 09-09-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51983



Parent Item: D3884-1RevB



Parent Item Name: Saddle, Inboard LH



Start Date: 09/11/2009

Required Date: 09/23/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-017RevB		Manufactured	No			100	Each	0.0000	4.0000			
												
Saddle Billet												

SF 09/09/21

2x47460

1x6101-013

batch 46413

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 51933
Description: Saddle, Inboard LH		Part Number: D3884-1
Inspection Dwg: D3884	Rev: B	Page 1 of 2

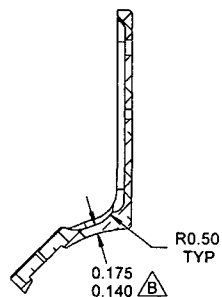
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

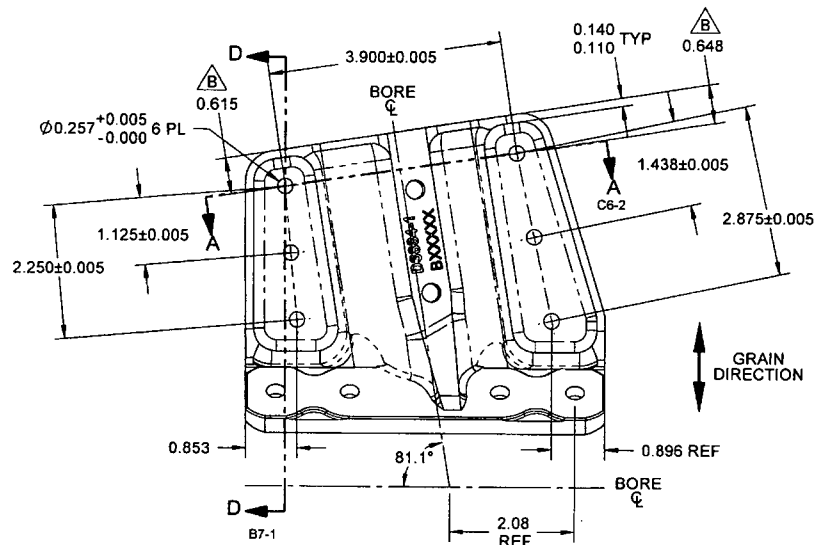
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.900	+ .005	3.900	✓			
2.250	"	2.249	✓			
1.125	"	1.124				
1.438	"	1.438	✓			
2.875	"	2.876	✓			
.648	± .010	.649	✓			
.615	"	.618	✓			
.250	"	.250	✓			
.140/.165	✓	.147	✓			
2.000	+ .020 - .000	2.012	✓			
.125	+ .010	.125	✓			
.250	"	.251	✓			
.140/.165	✓	.150	✓			
.250	± .010	.248	✓			
.110/.140	✓	.140	✓			
2.858	± .030	2.870	✓			
.750	"	.745	✓			
1.265	+ .020 - .000	1.272	✓			
.313	+ .005 - .000	.314	✓			
1.250	+ .005	1.250	✓			
.500	+ .010	.500	✓			
.316	+ .005 - .000	.314				
1.000	± .010	1.006	✓			

Measured by: <i>SS</i>	Audited by: <i>ml</i>	Prototype Approval:	N/A
Date: 09/09/21	Date: 09.09.21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

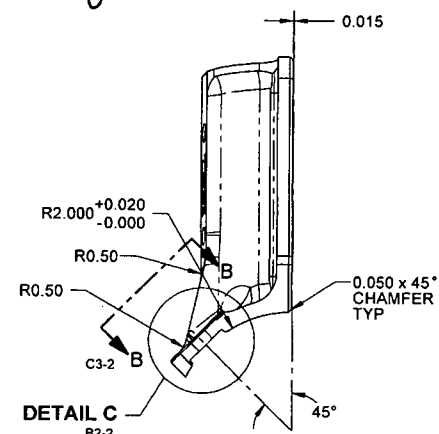
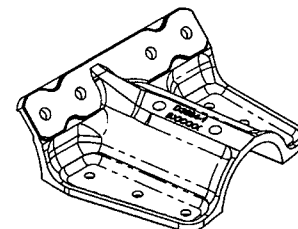


SECTION D-D B6-1



**D3884-1 SADDLE, INBOARD LH (SHOWN)
D3884-2 SADDLE, INBOARD RH (OPPOSITE)**

51983
MF
09-09-11



RELEASED
07/15/14

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C6-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.080. ZN C2-2; 0.75 WAS 0.65. ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.30		

DART AEROSPACE USA, INC.
PORT HADLOCK, VA

DRAWING NO. **D3884** REV. B
SHEET 1 OF 2
TITLE **INBOARD SADDLE** SCALE NTS

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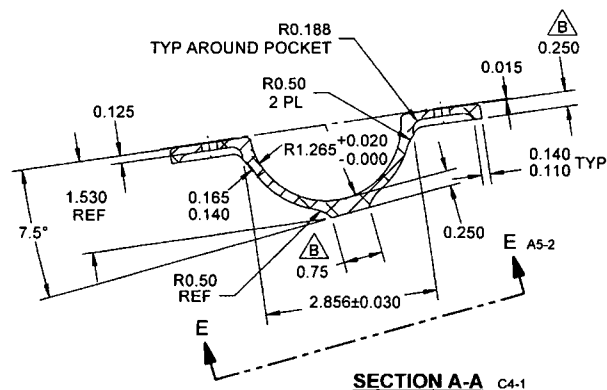
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

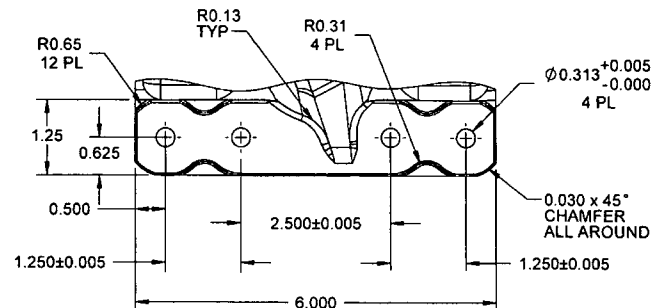
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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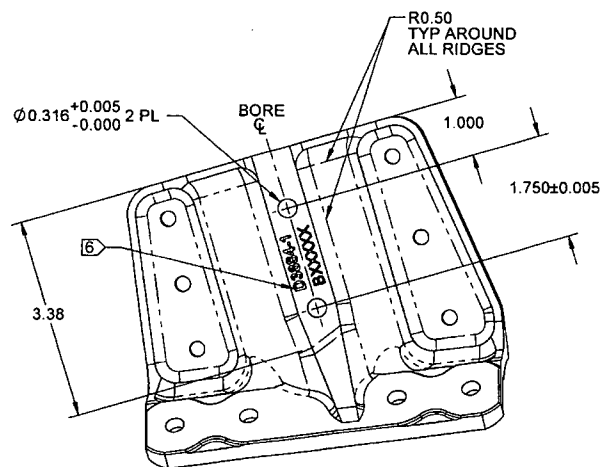
NOTE: Date & initial all entries



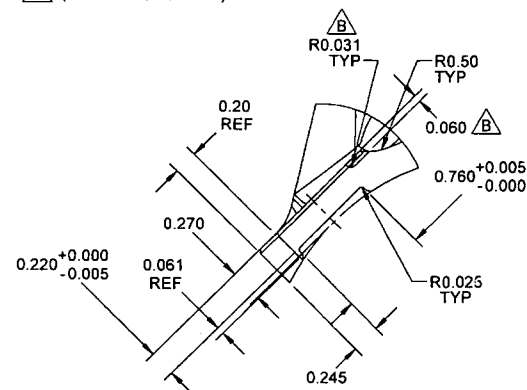
SECTION A-A C4-1



VIEW B-B B3-1
(ROTATED FOR CLARITY)



VIEW E-E C6-2



DETAIL C B3-1
SCALE 2X

RELEASED
09/15/10

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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